

Aero Design Ltd.**Work Order Control Sheet****Work Order#:** 2014-66 **Date Opened:** 8 Sep 2014 **Title:** Fabrication**Aircraft OEM:** Bell **Aircraft Model:** 206L/407 **Product Type:** Cargo Basket Mount Hoops **Product Model:** Wide **Quantity:** 10 Each**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification (Original)
Time Sheet (R&D)
Notes

Initial or N/A

JR
N/A
JR
JR
N/A
N/A
N/A
N/A

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components
Outside Processing

As Instructed

21
N/A
N/A
JR
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

JR
JR

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
White Tracking Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

N/A
N/A
N/A
N/A
JR
JR

Drawing List

Drawing #	Rev #	Description	Initial or N/A
94521	0	Forward Mount Hoop	JR
94522	0	Aft Mount Hoop	JR

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JR
N/A
N/A

Traveller

Fabricate Body and Lid Rims
Weld Body and Lid Rims
Fabricate Mount Hoops
Weld Mount Hoops
Fabricate Regular Hoops
Jig Body Assembly
Weld Body Assembly
Jig Lid as Required
Weld Lid

Initial or N/A

N/A
N/A
MR
DM
N/A
N/A
N/A
N/A
N/A

Install Mesh In Body
Weld Mesh In Body
Install Mesh On Lid
Weld Mesh On Lid
Install and Weld Remaining Lugs and Brackets
Tighten and Starighten Body and Lid As Required
Powder Coat Body and Lid
Assemble Completed Basket
ICC/ Dual Inspection

N/A
N/A
N/A
N/A
N/A
N/A
N/A
N/A
JR

Work performed by:

Print: Matthew /Dave

ICC / Dual Inspection performed by:

Print: Matthew

Work Order closed by:

Print: Jason RekveSign: [Signature]SCA: AD-06Date: 25-Jul-14Sign: [Signature]SCA: AD-05Date: 25-Jul-14Sign: [Signature]SCA: AD-01Date: 30-Sep-14

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014



Contains S/S notes

Aero Design Ltd.

AMF 73-04

9888 A Malaspina Rd.

Powell River, BC

Canada

V8A 0G3

Change Pictures

Complete Fabrication Instructions

This sheet is designed to assist in the fabrication of Aero Design products in accordance with the company Manufacturing Policy Manual, the Canadian Aviation Regulations and other applicable technical documentation.

The reference column of the following table is for reference unless a specific instruction is called out.

The initial columns serve one column per component fabricated on the applicable work order.

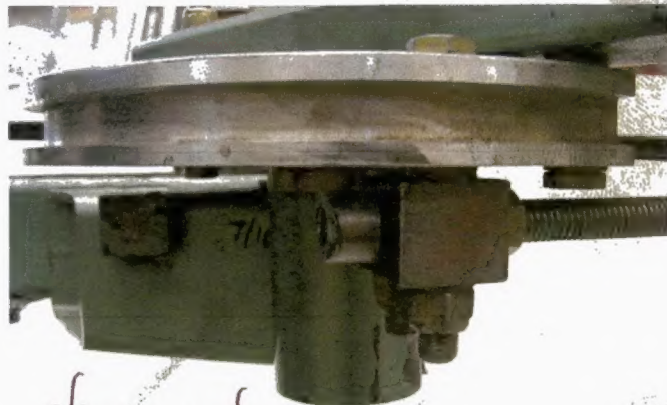
Nomenclature: Bell 407 Low Mounted Wide Aft Hoop Work Order #: 2014-66
Number of Units: 5

Bending Instructions

Model	Requirement	Reference	Initial				
Wide/Ski	Review LOEP to ensure most current technical specifications	DPM	MR				
Wide/Ski	Cut 1/2" x 0.035 material to 54 1/16" <i>54 5/16"</i> , square ends.	Drawing 94522	MR	MR	MR	MR	MR
Wide/Ski	De-burr end cuts using appropriate methods	N/A	MR	MR	MR	MR	MR
Wide/Ski	Remove writing on tubes using medium scotch bright and a light solvent.	N/A	MR	MR	MR	MR	MR
Wide/Ski	On the manual tubing bender ADT-501, set the upper stop to 19 7/32" <i>19 1/8"</i> <i>19" MARK TO INSURE 19 1/8"</i>	Fig. 1	MR	MR	MR	MR	MR
Wide/Ski	On the manual tubing bender ADT-501, set the lower stop to 12mm <i>105° on lower stop</i>	Fig. 2	MR	MR	MR	MR	MR
Wide/Ski	Slide stock tube through bending die ADT-501-003 up to upper stop.	Fig. 3	MR	MR	MR	MR	MR



Figure 1



change picture

Figure 2

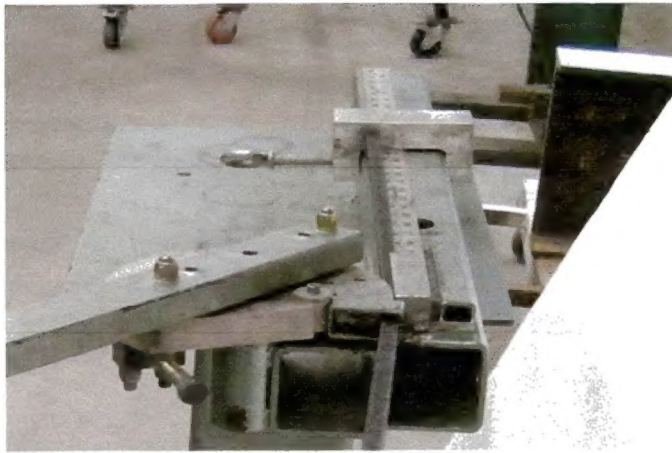


Figure 3

Caution:

Ensure the 1/2" tubing adapter remains tight against the tool rest throughout the bending process

Caution:

Ensure the tube remains tight against the stop until bend is started

Caution:

Ensure the draw bar handle remains horizontal throughout the bending process

Caution:

Be sure to pull draw bar in a medium speed constant pressure to ensure smooth radius

Note:

Complete each step on the first part and inspect for conformance to the applicable design data before continuing on to subsequent parts in the same batch

Wide/Ski	Pull draw bar ADT-501-002 until contact is made with the lower stop	Fig. 4/5	MR	MR	MR	MR	MR
Wide/Ski	Remove material from the bending fixture.	N/A	MR	MR	MR	MR	MR
Wide/Ski	With short end of tube pointing down, slide the long end of the tube into the 1" radius bender ADT-502 until the 4.5" radius contacts the bender. <i>33 3/4 mark lines up with C mark on bender (measure from long straight end).</i>	Fig. 6	MR	MR	MR	MR	MR
Wide/Ski	Pull draw bar until the edge of the fixture reaches the 30 degree mark on the table. <i>past 1/4 for s/s light wall.</i>	Fig. 7	MR	MR	MR	MR	MR
Wide/Ski	Remove material from the bending fixture.	N/A	MR	MR	MR	MR	MR
Wide/Ski	Measure and mark 3.5" from the center of the 1" radius down the long end of the tube. <i>30 1/2 from long straight end</i>	Fig. 8	MR	MR	MR	MR	MR
Wide/Ski	With short end of tube pointing up, slide the long end of the tube into the 1" radius bender ADT-502 until the mark on the tube is centered between the bolts on the fixture and the support block	Fig. 9	MR	MR	MR	MR	MR
Wide/Ski	Pull draw bar until the edge of the fixture reaches the 30 degree mark on the table. <i>past 1/4 for s/s light wall</i>	Fig. 7	MR	MR	MR	MR	MR



Fig. 4



Fig. 5



Figure 6



Figure 7



Figure 8



Figure 9

Wide/Ski	On the manual tubing bender ADT-501, set the upper stop to 19 15/32". 19 9/32 5/5 light wall 19 1/4 to 19 9/16	Fig. 1	MR	MR	MR	MR	MR
Wide/Ski	On the manual tubing bender ADT-501, set the lower stop to 12mm 105°	Fig. 2	MR	MR	MR	MR	MR
Wide/Ski	Slide stock tube through bending die ADT-501-003 up to upper stop.	Fig. 3	MR	MR	MR	MR	MR

Caution:

Ensure the 1/2" tubing adapter remains tight against the tool rest throughout the bending process

Caution:

Ensure the tube remains tight against the stop until bend is started

Caution:

Ensure the draw bar handle remains horizontal throughout the bending process

Caution:

Be sure to pull draw bar in a medium speed constant pressure to ensure smooth radius

Wide/Ski	Pull draw bar until contact is made with the lower stop	Fig. 4/5	MR	MR	MR	MR	MR
Wide/Ski	Remove material from the bending fixture.	N/A	MR	MR	MR	MR	MR
Wide/Ski	On the leg opposite the 30 degree joggle, place marks at 2.25" 4" and 9.5" 11.5"	Fig. 10	MR	MR	MR	MR	MR
Wide/Ski	With hoop pointing up, slide the end of the tube into the 1" radius bender ADT-502 until the 9.5" mark is in line with the pivot point of the bender. 11.5" C marks	Fig. 11	MR	MR	MR	MR	MR
Wide/Ski	Pull draw bar until the edge of the fixture reaches the 15 degree mark on the table.	Fig. 12	MR	MR	MR	MR	MR
Wide/Ski	Remove material from the bending fixture.	N/A	MR	MR	MR	MR	MR
Wide/Ski	With the hoop pointing down, slide the end of the tube into the 1" radius bender ADT-502 until the 2.25" mark is in line with the pivot bolt on the bender. 4"	Fig. 13	MR	MR	MR	MR	MR
Wide/Ski	Pull draw bar until the edge of the fixture reaches the 15 degree mark on the table.	Fig. 12	MR	MR	MR	MR	MR



Figure 10



Figure 11

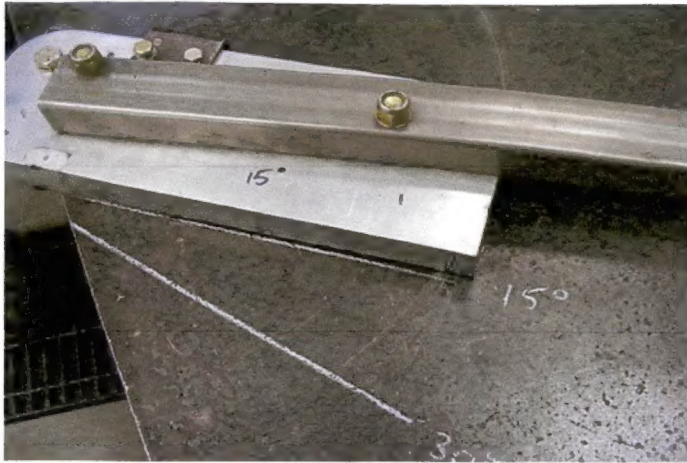


Figure 12



Figure 13

Milling Instructions

Wide/Ski	Install steel jaws in the manual milling machine vise.	Fig. 14	DRM	DRM	DRM	DRM	DRM
Wide/Ski	Insert mounting leg of hoop in milling machine vise with the end of leg pointing to the right.	Fig. 15	DRM	DRM	DRM	DRM	DRM



Figure 14

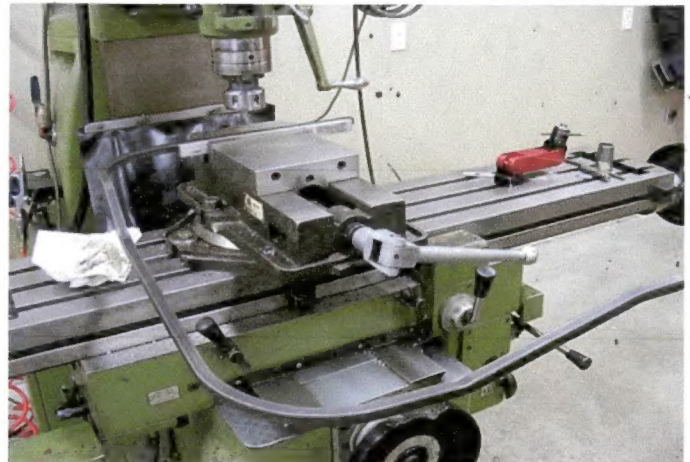


Figure 15

Caution:

Support the hoop using a backup bar in order to minimize deflection while milling. Fig. 15

Wide/Ski	Using 1/2" round bar, zero in X plane by touching off on the end of the tube by pinching feeler guage or paper to indicate contact.	Fig. 16	DRM	DRM	DRM	DRM	DRM
Wide/Ski	Push ZERO button for X on the digital readout	Fig. 17	DRM	DRM	DRM	DRM	DRM
Wide/Ski	Raise tool above the level of the material and shift left in X plane to -0.250	N/A	DRM	DRM	DRM	DRM	DRM

Wide/Ski	Push ZERO button for X on the digital readout	Fig. 17	DRM	DRM	DRM	DRM	DRM
Wide/Ski	Shift left to -2" on X plane and push ZERO button for X on digital readout	N/A	DRM	DRM	DRM	DRM	DRM
Wide/Ski	Push ZERO button for X on the digital readout	Fig. 17	DRM	DRM	DRM	DRM	DRM
Wide/Ski	Using 1/2" round bar, zero in Y plane by touching off on the backside of the tube by pinching feeler guage or paper to indicate contact.	N/A	DRM	DRM	DRM	DRM	DRM
Wide/Ski	Push ZERO button for Y on the digital readout	Fig. 18	DRM	DRM	DRM	DRM	DRM
Wide/Ski	Raise tool above the level of the material and shift forward in Y plane to -0.250	N/A	DRM	DRM	DRM	DRM	DRM
Wide/Ski	Push ZERO button for Y on the digital readout	Fig. 18	DRM	DRM	DRM	DRM	DRM

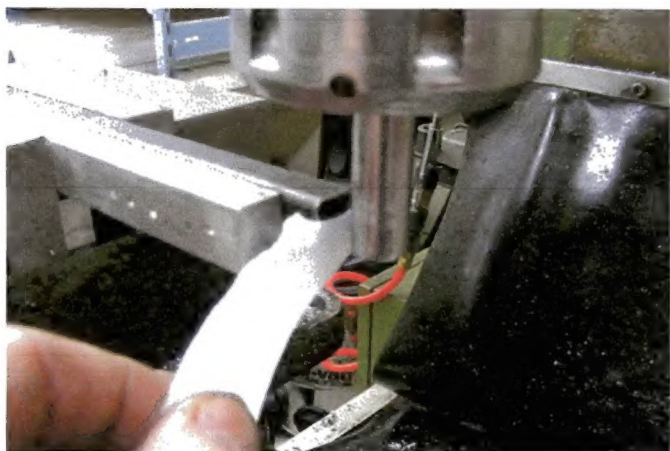


Figure 16



Figure 17



Figure 18

Caution:

Apply cutting oil to material surface at location to be milled

Wide/Ski	Using 5/8" (0.625) end mill, mill into side of tube.	Dwg. 94522	DRM	DRM	DRM	DRM	DRM
All	Using appropriate methods, remove the excess cutting fluid from the surface and inside of the tube.	N/A	DRM	DRM	DRM	DRM	DRM
All	De-burr milled cuts using appropriate methods.	N/A	mc	m	m	m	m
Wide/Ski	Using a #30 bit, drill vent holes for spine as indicated in note #2 on drawing.	Dwg. 94620	c/w	@	install	ch	
All	De-burr holes using appropriate methods	N/A	c/w	@	install	ch	

Welding Instructions

All	Attach two 69823-02 lugs to ADT-104-002 spacing jig using 3/8-24 bolt.	Fig. 19	DRM	DRM	DRM	DRM	DRM
All	Install the lugs mounted in the mounting jig assembly into slots milled in the hoop.	Dwg. 94522	DRM	DRM	DRM	DRM	DRM



Figure 19

Caution:

Ensure the lugs are centered laterally in tube before welding.

All	TIG weld both mounting lugs to hoop assembly around the entire mating surface between the two parts.	AWSD17.1/ D17.1M:2010	DRM	DRM	DRM	DRM	DRM
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Final Completion

All	Remove the ADT-104-002 jig fixture from the hoop assembly.	N/A	OK OK OK OK OK
All	De-burr threaded holes in lug using a 3/8-24 tap.	Standard Practice	OK OK OK OK OK
All	Inspect completed parts for quality of finish.	Standard Practice	OK OK OK OK OK
All	Using a flash light and a 10 power magnifying glass, inspect all weldments for quality and discoloration.	AWSD17.1/ D17.1M:2010	OK OK OK OK OK
All	Record the purchase order number and serial number (if required) on the Parts Distribution Sheet.	DIR	OK OK OK OK OK
All	Tag completed parts using an In-Process tag with the details of the work performed.	DIR	OK OK OK OK OK
All	Place completed assemblies in stores for distribution.	N/A	OK OK OK OK OK

Post Fabrication Inspection

Inspect components to ensure conformity to the applicable design data.

Signature: Jason Kuhn

Licence Number or SCA: ASO1

Date: 230 Sep 14 OK



Aero Design Ltd.

AMF 73-04

9888 A Malaspina Rd.

Powell River, BC

Canada

V8A 0G3

Change Pictures

Complete Fabrication Instructions

This sheet is designed to assist in the fabrication of Aero Design products in accordance with the company Manufacturing Policy Manual, the Canadian Aviation Regulations and other applicable technical documentation.

The reference column of the following table is for reference unless a specific instruction is called out.

The initial columns serve one column per component fabricated on the applicable work order.

Nomenclature: Bell 407 Low Mounted Wide Aft Hoop Work Order #: 2014-66
Number of Units: 5

Bending Instructions

Model	Requirement	Reference	Initial				
Wide/Ski	Review LOEP to ensure most current technical specifications	DPM	MR	MR	MR	MR	MR
Wide/Ski	Cut 1/2" x 0.035 material to 54 1/16" <u>54 1/16"</u> , square ends. <u>54 1/16"</u>	Drawing 94522	MR	MR	MR	MR	MR
Wide/Ski	De-burr end cuts using appropriate methods	N/A	MR	MR	MR	MR	MR
Wide/Ski	Remove writing on tubes using medium scotch bright and a light solvent.	N/A					
Wide/Ski	On the manual tubing bender ADT-501, set the upper stop to 19 7/32" <u>19 7/32"</u> <u>18 5/16 CS / To bender mark</u>	Fig. 1	MR	MR	MR	MR	MR
Wide/Ski	On the manual tubing bender ADT-501, set the lower stop to 12mm <u>105° mark</u>	Fig. 2	MR	MR	MR	MR	MR
Wide/Ski	Slide stock tube through bending die ADT-501-003 up to upper stop.	Fig. 3	MR	MR	MR	MR	MR



Figure 1

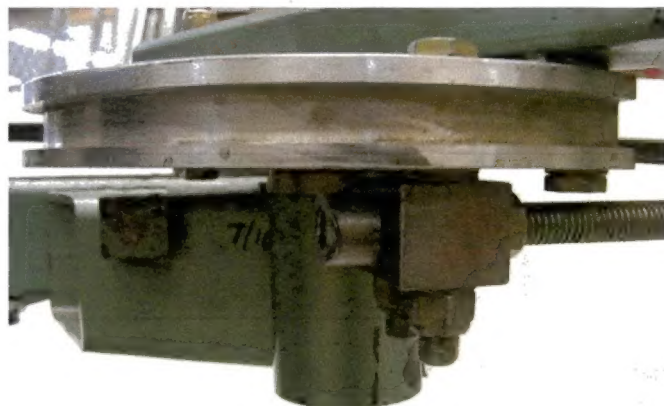


Figure 2



Figure 3

Caution:

Ensure the 1/2" tubing adapter remains tight against the tool rest throughout the bending process

Caution:

Ensure the tube remains tight against the stop until bend is started

Caution:

Ensure the draw bar handle remains horizontal throughout the bending process

Caution:

Be sure to pull draw bar in a medium speed constant pressure to ensure smooth radius

Note:

Complete each step on the first part and inspect for conformance to the applicable design data before continuing on to subsequent parts in the same batch

Wide/Ski	Pull draw bar ADT-501-002 until contact is made with the lower stop	Fig. 4/5	MR	MR	MR	MR	MR
Wide/Ski	Remove material from the bending fixture.	N/A	MR	MR	MR	MR	MR
Wide/Ski	With short end of tube pointing down, slide the long end of the tube into the 1" radius bender ADT-502 until the 4.5" radius contacts the bender.	Fig. 6	MR	MR	MR	MR	MR
Wide/Ski	Pull draw bar until the edge of the fixture reaches the 30 degree mark on the table.	Fig. 7	MR	MR	MR	MR	MR
Wide/Ski	Remove material from the bending fixture.	N/A	MR	MR	MR	MR	MR
Wide/Ski	Measure and mark 3.5" from the center of the 1" radius down the long end of the tube.	Fig. 8	MR	MR	MR	MR	MR
Wide/Ski	With short end of tube pointing up, slide the long end of the tube into the 1" radius bender ADT-502 until the mark on the tube is centered between the bolts on the fixture and the support block	Fig. 9	MR	MR	MR	MR	MR
Wide/Ski	Pull draw bar until the edge of the fixture reaches the 30 degree mark on the table.	Fig. 7	MR	MR	MR	MR	MR



Fig. 4



Fig. 5



Figure 6



Figure 7



Figure 8



Figure 9

Wide/Ski	On the manual tubing bender ADT-501 , set the upper stop to 19-15/32".	Fig. 1	MR	MR	MR	MR	MR
Wide/Ski	On the manual tubing bender ADT-501 , set the lower stop to 12mm	Fig. 2	MR	MR	MR	MR	MR
Wide/Ski	Slide stock tube through bending die ADT-501-003 up to upper stop.	Fig. 3	MR	MR	MR	MR	MR

Caution:

Ensure the 1/2" tubing adapter remains tight against the tool rest throughout the bending process

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Wide/Ski	Pull draw bar until contact is made with the lower stop	Fig. 4/5	MR	MR	MR	MR	MR
Wide/Ski	Remove material from the bending fixture.	N/A	MR	MR	MR	MR	MR
Wide/Ski	On the leg opposite the 30 degree joggle, place marks at 2.25" and 9.5"	Fig. 10	MR	MR	MR	MR	MR
Wide/Ski	With hoop pointing up, slide the end of the tube into the 1" radius bender ADT-502 until the 9.5" mark is in line with the pivot point of the bender.	Fig. 11	MR	MR	MR	MR	MR
Wide/Ski	Pull draw bar until the edge of the fixture reaches the 15 degree mark on the table.	Fig. 12	MR	MR	MR	MR	MR
Wide/Ski	Remove material from the bending fixture.	N/A	MR	MR	MR	MR	MR
Wide/Ski	With the hoop pointing down, slide the end of the tube into the 1" radius bender ADT-502 until the 2.25" mark is in line with the pivot bolt on the bender.	Fig. 13	MR	MR	MR	MR	MR
Wide/Ski	Pull draw bar until the edge of the fixture reaches the 15 degree mark on the table.	Fig. 12	MR	MR	MR	MR	MR



Figure 10

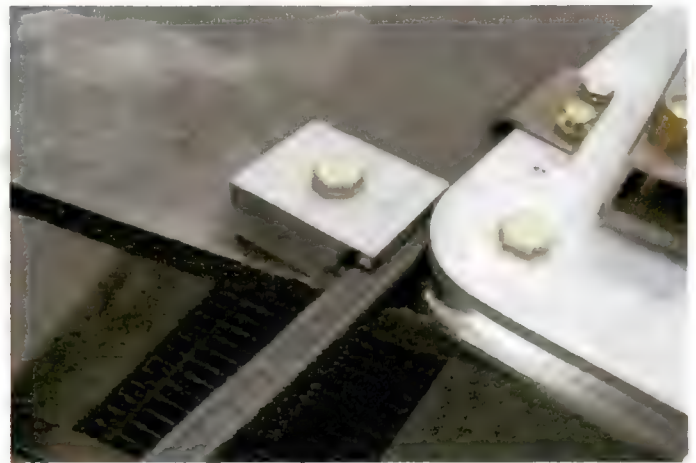


Figure 11



Figure 12



Figure 13

Milling Instructions

Wide/Ski	Install steel jaws in the manual milling machine vise.	Fig. 14	DRM	DRM	DRM	DRM	DRM
Wide/Ski	Insert mounting leg of hoop in milling machine vise with the end of leg pointing to the right.	Fig. 15	DRM	DRM	DRM	DRM	DRM



Figure 14

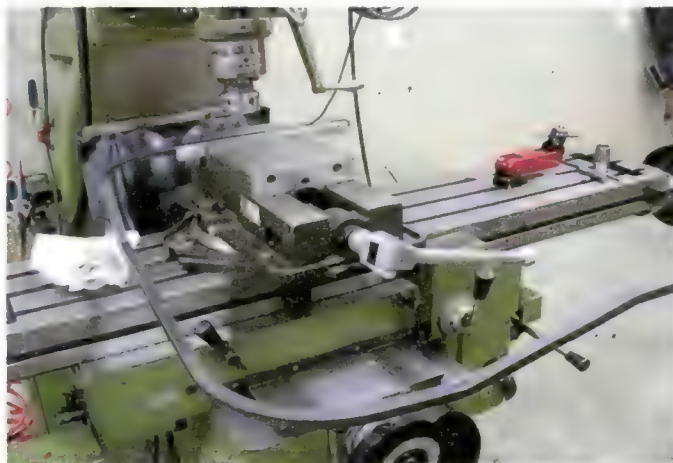


Figure 15

Caution:

Support the hoop using a backup bar in order to minimize deflection while milling. Fig. 15

Wide/Ski	Using 1/2" round bar, zero in X plane by touching off on the end of the tube by pinching feeler guage or paper to indicate contact.	Fig. 16	DRM	DRM	DRM	DRM	DRM
Wide/Ski	Push ZERO button for X on the digital readout	Fig. 17	DRM	DRM	DRM	DRM	DRM
Wide/Ski	Raise tool above the level of the material and shift left in X plane to -0.250	N/A	DRM	DRM	DRM	DRM	DRM

Wide/Ski	Push ZERO button for X on the digital readout	Fig. 17	DRM	DRM	DRM	DRM	DRM
Wide/Ski	Shift left to -2" on X plane and push ZERO button for X on digital readout	N/A	DRM	DRM	DRM	DRM	DRM
Wide/Ski	Push ZERO button for X on the digital readout	Fig. 17	DRM	DRM	DRM	DRM	DRM
Wide/Ski	Using 1/2" round bar, zero in Y plane by touching off on the backside of the tube by pinching feeler guage or paper to indicate contact.	N/A	DRM	DRM	DRM	DRM	DRM
Wide/Ski	Push ZERO button for Y on the digital readout	Fig. 18	DRM	DRM	DRM	DRM	DRM
Wide/Ski	Raise tool above the level of the material and shift forward in Y plane to -0.250	N/A	DRM	DRM	DRM	DRM	DRM
Wide/Ski	Push ZERO button for Y on the digital readout	Fig. 18	DRM	DRM	DRM	DRM	DRM

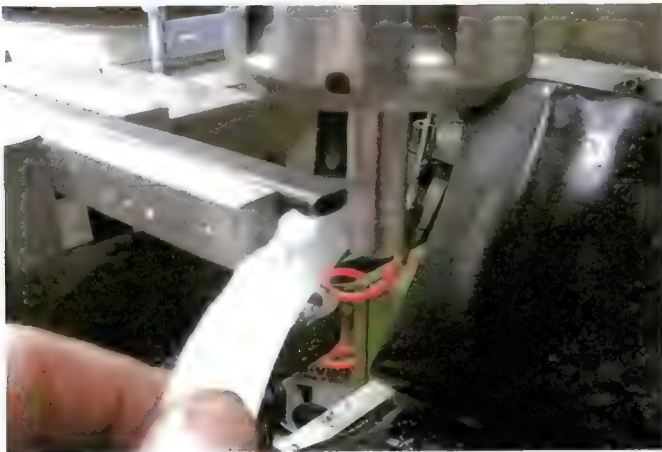


Figure 16



Figure 17



Figure 18

Caution:

Apply cutting oil to material surface at location to be milled

Wide/Ski	Using 5/8" (0.625) end mill, mill into side of tube.	Dwg. 94522	DRM	DRM	DRM	DRM	DRM
All	Using appropriate methods, remove the excess cutting fluid from the surface and inside of the tube.	N/A	DRM	DRM	DRM	DRM	DRM
All	De-burr milled cuts using appropriate methods.	N/A	DRM	DRM	DRM	DRM	DRM
Wide/Ski	Using a #30 bit, drill vent holes for spine as indicated in note #2 on drawing.	Dwg. 94620	c/w @	install	ok		
All	De-burr holes using appropriate methods	N/A	c/w @	install	ok		

Welding Instructions

All	Attach two 69823-02 lugs to ADT-104-002 spacing jig using 3/8-24 bolt.	Fig. 19	DRM	DRM	DRM	DRM	DRM
All	Install the lugs mounted in the mounting jig assembly into slots milled in the hoop.	Dwg. 94522	DRM	DRM	DRM	DRM	DRM



Figure 19

Caution:

Ensure the lugs are centered laterally in tube before welding.

All	TIG weld both mounting lugs to hoop assembly around the entire mating surface between the two parts.	AWSD17.1/ D17.1M:2010	DRM	DRM	DRM	DRM	DRM
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Final Completion

All	Remove the ADT-104-002 jig fixture from the hoop assembly.	N/A	DRM	DRM	DRM	DRM	DRM
All	De-burr threaded holes in lug using a 3/8-24 tap.	Standard Practice	c/w	2)	install	ok	
All	Inspect completed parts for quality of finish.	Standard Practice	ok	ok	ok	ok	ok
All	Using a flash light and a 10 power magnafying glass, inspect all weldments for quality and discoloration.	AWSD17.1/ D17.1M:2010	c/w	before	mesh	install	ok
All	Record the purchase order number and serial number (if required) on the Parts Distribution Sheet.	DIR	ok	ok	ok	ok	ok
All	Tag completed parts using an In-Process tag with the details of the work performed.	DIR	ok	ok	ok	ok	ok
All	Place completed assemblies in stores for distribution.	N/A	ok	ok	ok	ok	ok

Post Fabrication Inspection

Inspect components to ensure conformity to the applicable design data.

Signature: Oliver Rehn

Licence Number or SCA: AD 01

Date: 30 Sep 14

CARGO BASKET HOOP FABRICATION – 94521

General

These instructions apply to cargo basket forward attachment hoop 69821-01. Refer to the following drawings, at the current revision, for dimensions and details:

94520, Revision 0 – Basket Component - Hoop

94521, Revision 0 – Forward Attachment Hoop

Work Order: 2014-66

Complete
(initial or SCA #)

Date Open: 8 Sep 14

1. Forward Attachment Hoop – Preparation – 94521-01 IK IK IK IK IK
 - a. Start with 94520-01 hoop as stock.
 - b. Setup manual milling machine with standard steel vise jaw, with a backup bar to prevent the hoop from deflecting while cutting. Set XY 0 on far, right edge of hoop (end of hoop). Shift X along hoop 2.0" and set X 0.
 - c. Using 5/8" (0.625) end mill, mill into side of tube in accordance with drawing. Apply a few drops of Rapid-Tap cutting oil to each location before milling.
 - d. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
 - e. Tag in process hoop(s) and place into stock.
2. Forward Attachment Hoop – Welding – 94521-01 DRM DRM DRM DRM DRM
 - a. Attach two 69823-02 lugs to 11" spacing jig using 3/8-24 bolt. Align lugs to slots in hoop prepared in step 1. above. Centre bolts on hoop.
 - b. TIG weld lugs into hoop. Weld all around both lugs.
 - c. Record lug and welding rod PO/WO on attached material list.
 - d. Tag in process hoop(s) and place into stock.
3. Forward Attachment Hoop – Finish – 94521-01 IK IK IK IK IK
 - a. Run 3/8-24 tap through welded lugs.
 - b. Inspect hoop for conformity to drawing.
 - c. Tag complete and inspected hoop(s) and place into stock.

CARGO BASKET HOOP FABRICATION – 94521

General

These instructions apply to cargo basket forward attachment hoop 69821-01. Refer to the following drawings, at the current revision, for dimensions and details:

94520, Revision 0 – Basket Component - Hoop

94521, Revision 0 – Forward Attachment Hoop

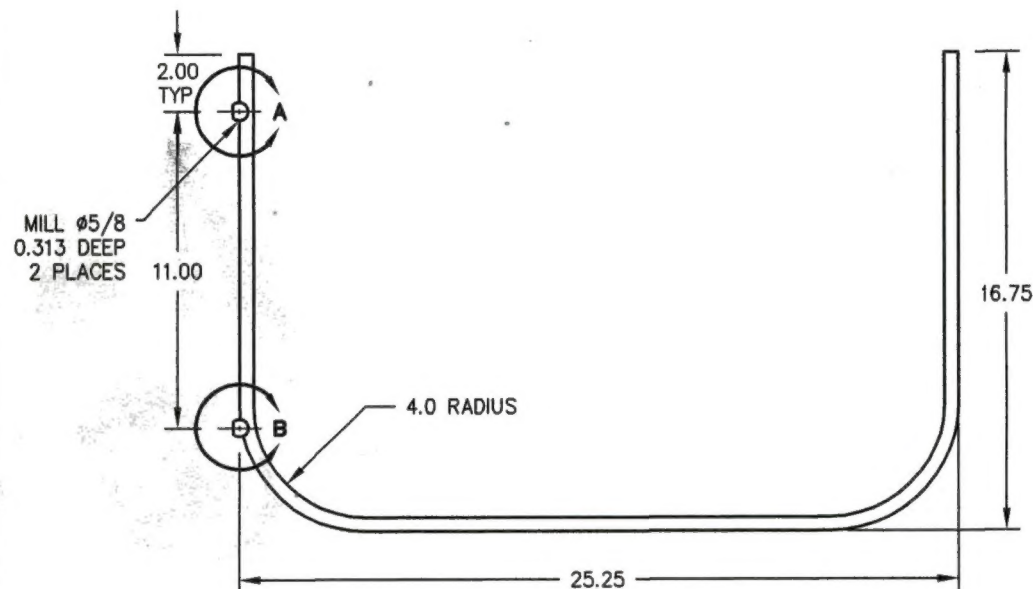
Work Order: 2014-66

Complete
(initial or SCA #)

Date Open: 8 Sep 14

1. Forward Attachment Hoop – Preparation – 94521-01 MC MC MC MC MC
 - a. Start with 94520-01 hoop as stock.
 - b. Setup manual milling machine with standard steel vise jaw, with a backup bar to prevent the hoop from deflecting while cutting. Set XY 0 on far, right edge of hoop (end of hoop). Shift X along hoop 2.0" and set X 0.
 - c. Using 5/8" (0.625) end mill, mill into side of tube in accordance with drawing. Apply a few drops of Rapid-Tap cutting oil to each location before milling.
 - d. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
 - e. Tag in process hoop(s) and place into stock.
2. Forward Attachment Hoop – Welding – 94521-01 DRM DRM DRM DRM DRM
 - a. Attach two 69823-02 lugs to 11" spacing jig using 3/8-24 bolt. Align lugs to slots in hoop prepared in step 1. above. Centre bolts on hoop.
 - b. TIG weld lugs into hoop. Weld all around both lugs.
 - c. Record lug and welding rod PO/WO on attached material list.
 - d. Tag in process hoop(s) and place into stock.
3. Forward Attachment Hoop – Finish – 94521-01 MC MC MC MC MC
 - a. Run 3/8-24 tap through welded lugs.
 - b. Inspect hoop for conformity to drawing.
 - c. Tag complete and inspected hoop(s) and place into stock.

[illegible]

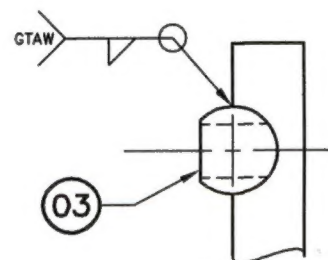


① FORWARD HOOP

NOTES:

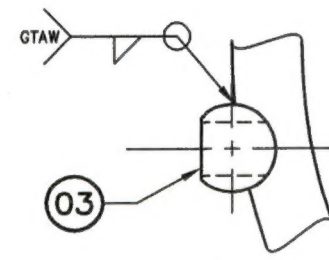
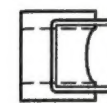
1. REMOVE ALL BURRS AND SHARP EDGES.
2. DRILL $3/32$ " VENT HOLE IN BOTTOM OF HOOPS FOR VENTING WELD GASES.
3. WELDING OF LUGS TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0			



DETAIL A

SCALE 1 : 1



DETAIL B

SCALE 1 : 1

2	69823-02	02	LUG	1018 MILD STEEL	AIISI 1010/1020	5/8 ROD
	94521-01	01	FORWARD HOOP	4130 STEEL COND. N	MIL-T-6736	1/2 x 0.035 SQR. TUBE
QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE

LIST OF MATERIALS

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	<p>UNLESS OTHERWISE SPECIFIED</p> <p>DIMENSIONS ARE IN INCHES.</p> <p>TOLERANCES ON:</p> <p>DECIMALS ANGLES</p> <p>X.XXX ± 0.010 $\pm 1/2^\circ$</p> <p>X.XX ± 0.03</p> <p>X.X ± 0.1</p>				<p>BELL 206L SERIES, 407</p> <p>QUICK RELEASE CARGO BASKET</p> <p>FORWARD HOOP</p>
	<p>SCALE 1 : 5</p>		<p>DWG. SIZE</p> <p>LGL</p>		<p>DWG. NO.</p> <p>94521</p>
	<p>SHEET 1 OF 1</p>		<p>REV.</p> <p>0</p>		

